

Work Order ID 62829

Page 1

Friday, October 08, 2010 12:48:49 PM

Item ID: D3686-041

Accept



Setup Start



Revision ID:

Item Name: MONOPOD ASSEMBLY

Stop



Start Date: 10/8/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10/8

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3686	Rev D



Packaging

Packaging

Pick Kit

0.00

100



Memo

0.00

Small Fab

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3686

2-Assemble D3693-1 & D3691-1 &D3693-3 &D3688-7 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3686

***Ensure holes for AN3C Bolts are free of sealant.
Torque Fastners as per Dwg D3686

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC5- Inspect part completeness to step on W/O

0.00

2

10/10/14

QC

Quality Control

130



Identify as per dwg & Stock Location: 177

0.00

10/10/18 2

Packaging

Packaging

140



QC21- Final Inspection - Work Order Release

0.00

10/10/18 2

QC

Quality Control

CMF

10-10-18

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Picklist Print

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Work Order ID: 62829



Parent Item: D3686-041



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A new issue 08-02-12 DD verified by:JLM
IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3688-7 		Manufactured	No			110	Each	7.0000	1	2		<i>EJ 10/10/14</i>	
STUD													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST081			7						
				44686			1						
				50931			6						
D3689-1 		Manufactured	No			110	Each	6.0000	1	2		<i>EJ 10/10/14</i>	
SLEEVE													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST76			6						
				62188			6						
D3691-1 		Manufactured	No			110	Each	25.0000	1	2		<i>EJ 10/10/14</i>	
STUD													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST077			16						
				61370			16						
				ST082			9						
				58631			9						

W/O:		WORK ORDER CHANGES					
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Work Order ID: 62829



Parent Item: D3686-041



Parent Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

D3692-1



Manufactured No

110

Each

305.0000

4

8

SPACER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	305	
51467	305	

D3692-3



Manufactured No

110

Each

41.0000

4

8

SPACER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	41	
44690	41	

D3693-1



Manufactured No

110

Each

34.0000

1

2

Rod End Bearing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	34	
50734	34	

D3693-3



Manufactured No

110

Each

5.0000

1

2

Rod End Bearing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST082	5	
50723	5	

AN3C10A



Purchased No

110

Each

34.0000

2

4

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	34	
105940	14	
112489	20	

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: MONOPOD ASSEMBLY

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 2.00

Required Qty: 2.00

AN3C12A



Purchased No

110

Each

50.0000

2



4
EB 10/10/14

Bolts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	50	
112314	8	
114761	11	
115392	11	
115594	20	

MS21043-3



Purchased No

110

Each

2,579.000

4



8
EB 10/10/14

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	76	
103691	76	
ST301	2503	
111383	38	
112314	2465	

NAS509L12C



Purchased No

110

Each

45.0000

1



2
EB 10/10/14

Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	45	
112314	35	
112828	10	

NAS509-12C



Purchased No

110

Each

40.0000

1



2
EB 10/10/14

Nuts

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST280	40	
112453	40	

W/O:		WORK ORDER CHANGES					
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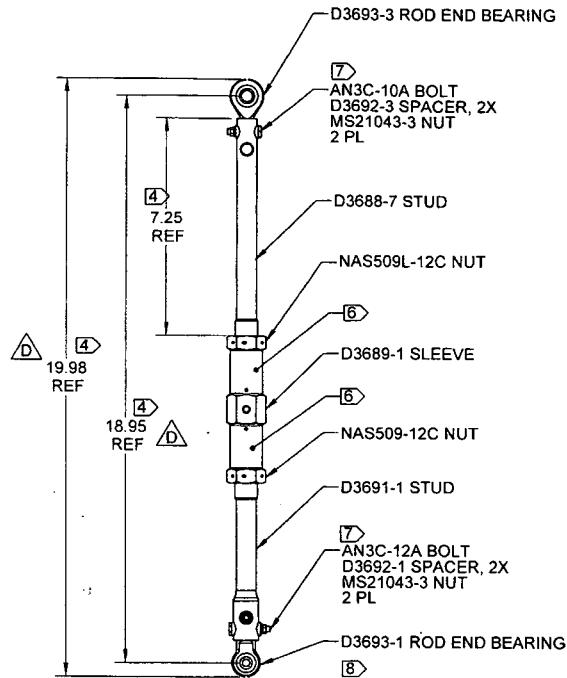
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ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3686-041	MONPOD ASSEMBLY
2	1	D3688-7	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	4	D3692-3	SPACER
7	1	D3693-1	ROD END BEARING
8	1	D3693-3	ROD END BEARING
9	2	AN3C-10A	BOLT
10	2	AN3C-12A	BOLT
11	4	MS21043-3	NUT
12	1	NAS509L-12C	NUT
13	1	NAS509-12C	NUT



D3686-041 MONPOD ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3686-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-7 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 3.0 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 & D3693-3 WITH D3688-7 USING SIKAFLX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

UNCONTR
SUBJ

NO. 42829
B810-10-8



RELEASED
2010-03-15
MM

D	19.98 WAS 20.10 (ZN C6-1); 18.95 WAS 19.07 (ZN C5-1)	RF	10.03.03
C	ROD END BEARINGS NOW ASSEMBLED USING SEALANT (ZN A8-1, B4-1)	RF	08.12.15
B	REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3686 REV. D	
MFG. APPR.		SHEET 1 OF 1	
APPROVED		TITLE MONOPOD ASSEMBLY	
DE APPR.		SCALE NTS	
DATE 10.03.03		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY MATERIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPYING, REPRODUCTION, OR DISSEMINATION BY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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